

Work Order ID 73345

Wednesday, August 31, 2011 11:06:35 AM



Page 1

Item ID:	D3564-9	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	9/1/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	9/15/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-09-01</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100		FLOW WATER JET	0.00						
	Waterjet	Memo	0.00						
	FLOW CNC Waterjet	1-Cut as per Dwg D3564 ***** (D3564-1F) ***** <input type="checkbox"/> Dwg Rev: <u>D</u> <input type="checkbox"/> Prog							
	304 . 063	Rev: <u>D</u> <input type="checkbox"/> 2-Deburr if necessary							
									<u>B11-9-13</u>
									<u>(20)</u>
110		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC	Memo	0.00						
	Quality Control								<u>B11-9-13</u>
120		QC8- Inspect parts - second check	0.00						
	QC	Memo	0.00						
	Quality Control								<u>counted</u> <u>x20</u>

Sutcliffe

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73345

Wednesday, August 31, 2011 11:06:35 AM



Page 2

Item ID: D3564-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00				<u>20</u>			
Brake NC	Memo	0.00							
Brake NC	Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 <input type="checkbox"/> Form Joggle as per Dwg D3564 on brake using Jig DT 8157								
140 	QC5- Inspect part completeness to step on W/O	0.00				<u>20</u>			
QC	Memo	0.00							
Quality Control	Ensure joggle as per dwg D3429								
150 	Large Fab	0.00				<u>20</u>			
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch <input type="checkbox"/> A/R								
	M118807 <input type="checkbox"/> Weld hardcoat as per Dwg D3564								

SP 11/09/11

8/10/11

count

20

20 11-09-22 JBL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

Item ID: D3564-9

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Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

8:00

M117338

counter
+120

20X M-11/09/23

W/O:		WORK ORDER CHANGES					
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Page 4

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Required Date: 9/15/2011	Req'd Qty: 20.00				
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC3- Inspect Part Finish	0.00							
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QC	Memo	0.00							

Quality Control

200	Identify as per dwg & Stock Location:	0.00							
-----	---------------------------------------	------	--	--	--	--	--	--	--

Packaging	Memo	0.00							

Packaging

210	QC21- Final Inspection - Work Order Release	0.00							
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QC	Memo	0.00							

Quality Control

20 PK 11-9-24

20x Ø M-Lu/23

11/9/27

11-07-23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 11:06:32 AM

Page 1

Work Order ID: 73345



Parent Item: D3564-9



Parent Item Name: Wearshoe

Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA		Purchased	No			100	sf	129.1000	1.41	29.68421			
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304/316 Sheet .063

B11-9-13

Location

Loc Qty

Loc Code

MAT020

116.5

118578

116.5

MAT021

12.6

118217

12.6

11827



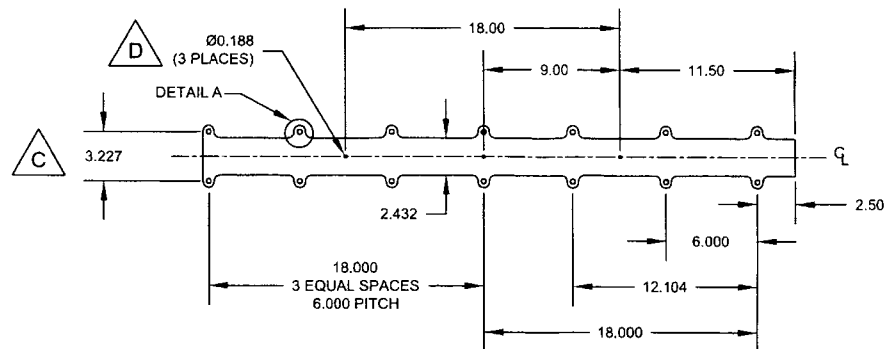
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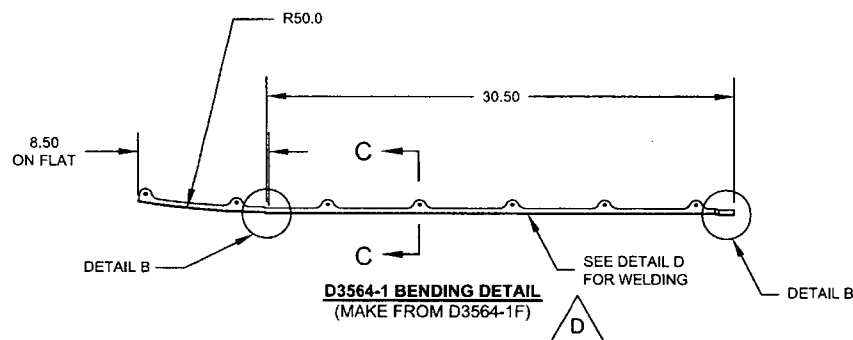
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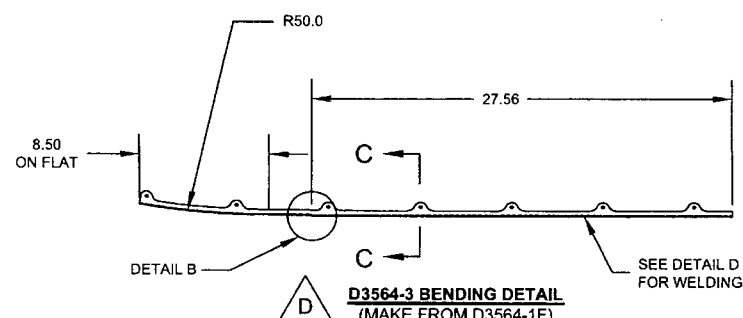
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

#70345

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

RELEASED

07.09.04

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8; UPDATE NOTES; PG1 A8, PG3 B5,C5; ADD D3564-15; PG1 B6,B3; D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3; D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3; D3564-9/-11 WAS ON PG1; PG3 B8,C8; D3564-13 WAS ON PG2; PG3 D2; WELDING DETAIL WAS ON PG1 PG3 A5,7,B2; RELOCATE DETAILS AND SECTION; PG3 A5,7,B2; INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3564	REV. D SHEET 1 OF 3
TITLE WEARSHOE	SCALE 1:8

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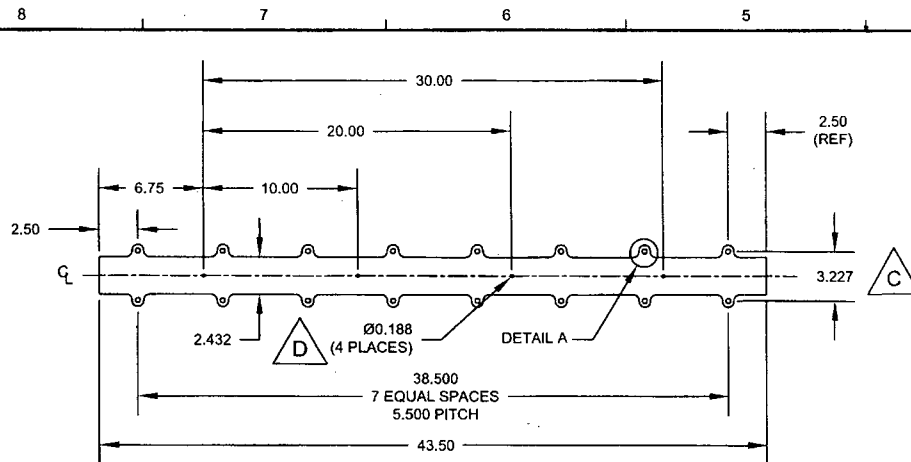
W/O:		WORK ORDER CHANGES					
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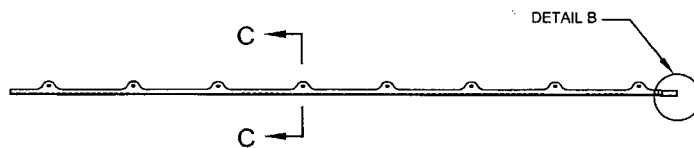
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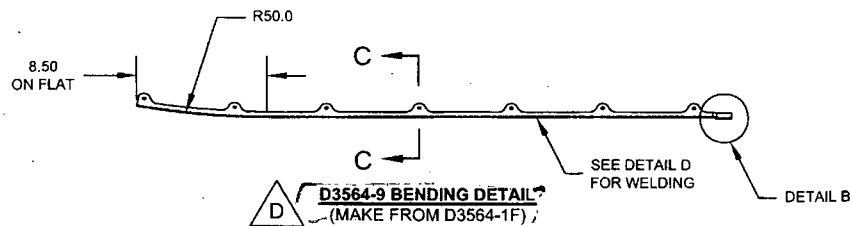
NOTE: Date & initial all entries



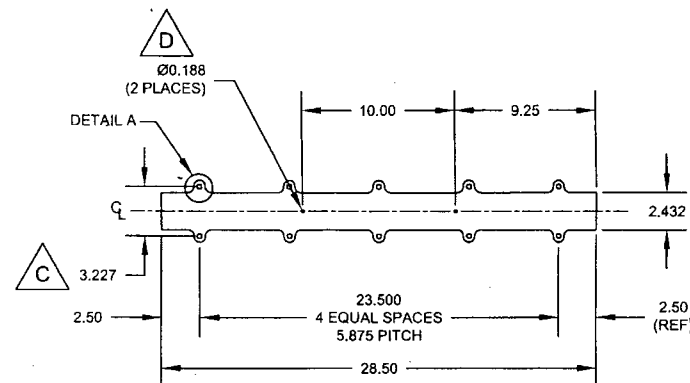
D3564-5F FLAT PATTERN



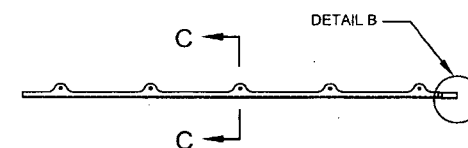
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



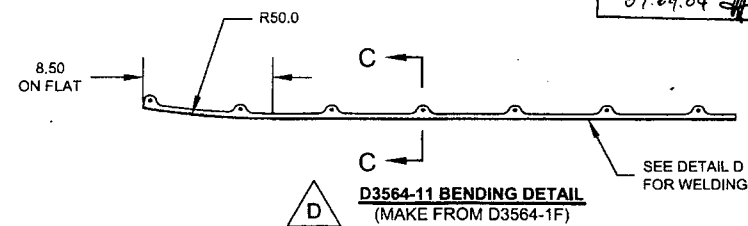
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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07.09.04

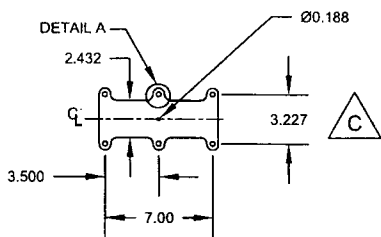
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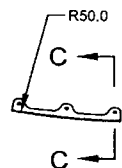
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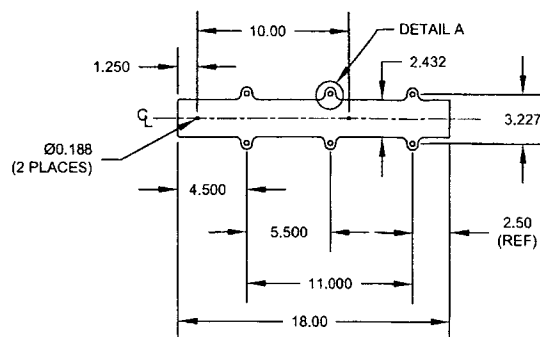
NOTE: Date & initial all entries



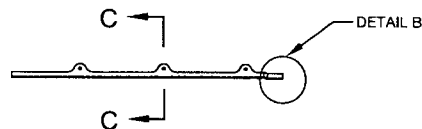
D3564-13F FLAT PATTERN



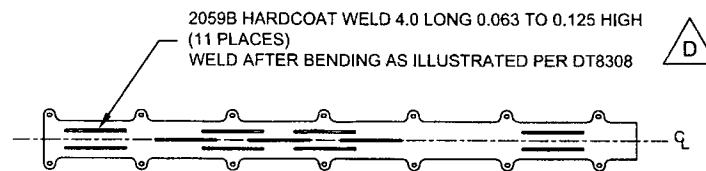
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



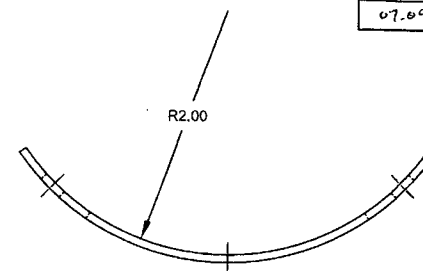
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



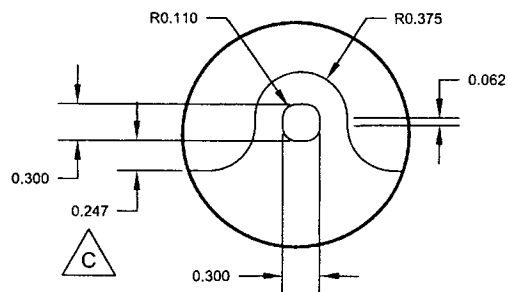
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED

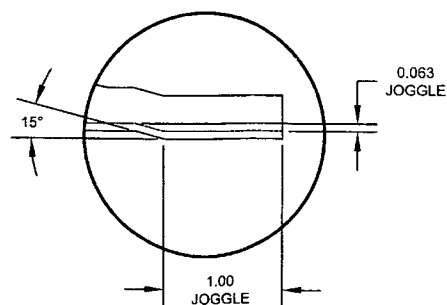
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

73345

DESIGN	PH	DART AEROSPACE LTD	
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CHECKED	PH	DRAWING NO. D3564	REV. D SHEET 3 OF 3
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DART AEROSPACE LTD		Work Order:	73345
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.222	x		V HB02	
2.432	+/-0.010	2.430	✓		V	
2.50	+/-0.030	2.500	✓		V	
6.000	+/-0.010	6.000	x		T HB01	
12.104	+/-0.010	12.104	x		T	
18.000	+/-0.010	18.000	x		T	
18.000	+/-0.010	18.000	✓		T	
18.00	+/-0.030	18.00	x		T	
9.00	+/-0.030	9.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
0.300 x 0.300	+/-0.010	302x.305	✓		V	
Ø0.188	+0.005/-0.001	.191	x		V	
R0.375	+/-0.010	.375	✓		R.G.	
0.063	+/-0.010	.058	x		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-9-13	Date: 11/09/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	AS

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